

Work Order ID 66155-1

Monday, February 07, 2011 11:20:49 AM



Page 1

Item ID: D3278-041

Accept



Setup Start



Revision ID:

Item Name: Support Assembly

Stop



Start Date: 2/8/2011 Start Qty: 60.00

Required Date: 2/22/2011 Req'd Qty: 60.00



Cust Item ID:

Customer:



Reference:

Approvals: Process Plan:

Date: 11-02-07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3278

Rev C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Rivet spacers with support as per Dwg D3278.

EP 11/02/24 (9)

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

ml 11 02 24 (9)

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble support as per Dwg D3278. ***DO NOT TIGHTEN BOLTS*** Identify as D3278-041

EP 11/02/24 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66155

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Item ID: D3278-041

Accept



Setup Start



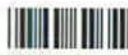
Revision ID:

Item Name: Support Assembly

Stop



Start Date: 2/8/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 60.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

ml 11 02 24 (9)

140

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

11/02/24 (4)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/24 JF

mf 11-02-24

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Picklist Print

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Page 1

Work Order ID: 66155

Parent Item: D3278-041

Parent Item Name: Support Assembly



Start Date: 2/8/2011

Required Date: 2/22/2011

Start Qty: 60.00

Required Qty: 60.00

Comments:

IPP: ☐ A ☐ 04.04.19 ☐ New issue ☐ KJ/JLM ☐

IPP B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-13A

Purchased

No

120

Each

682.0000

2

120



Bolt

Location

Loc Qty

Loc Code

ST357

682

116191

7

116669

375

116786

300

18

AN960JD416

NAS1149D0463J

Purchased

No

120

Each

30.0000

4

240



Washer

47 1116805 (36x)

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

18

D2230-1

Manufactured

No

120

Each

61.0000

2

120



Lug

Location

Loc Qty

Loc Code

ST476

61

64423

61

18

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 66155

Parent Item: D3278-041

Parent Item Name: Support Assembly

Start Date: 2/8/2011

Required Date: 2/22/2011

Start Qty: 60.00

Required Qty: 60.00

D3278-1



Support

Manufactured

No

100

Each

11.0000

1

60



EP 5/11/02/24

Location

Loc Qty

Loc Code

GE

4

62482

4

ST048

7

51353

7

4 *B65074 (5X)*

D3278-2



Support

Manufactured

No

100

Each

10.0000

1

60



EP 5/11/02/24

Location

Loc Qty

Loc Code

CA

7

62483

19

ST045

2

62022

2

ST048

1

60565

1

B65075 (40X)

D3278-3



Spacer

Manufactured

No

100

Each

69.0000

1

60



EP 5/11/02/24

Location

Loc Qty

Loc Code

GA

55

65076

55

ST045

14

60244

14

30
19

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 3

Work Order ID: 66155

Parent Item: D3278-041

Parent Item Name: Support Assembly



Start Date: 2/8/2011

Required Date: 2/22/2011

Start Qty: 60.00

Required Qty: 60.00

MS20426AD3-6

Purchased

No

120

Each

4,641.000

4

240



Rivet



JS 11/02/24

36

Location

Loc Qty

Loc Code

ST316

4641

105055

1071

116289

3570

MS21042L4

Purchased

No

100

Each

3,720.000

2

120



Nut



JS 11/02/24

18

Location

Loc Qty

Loc Code

ST300

3720

1123143

2

115589

10

115621

21

116188

3500

116548

187

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Shop Packet Print

Page 3

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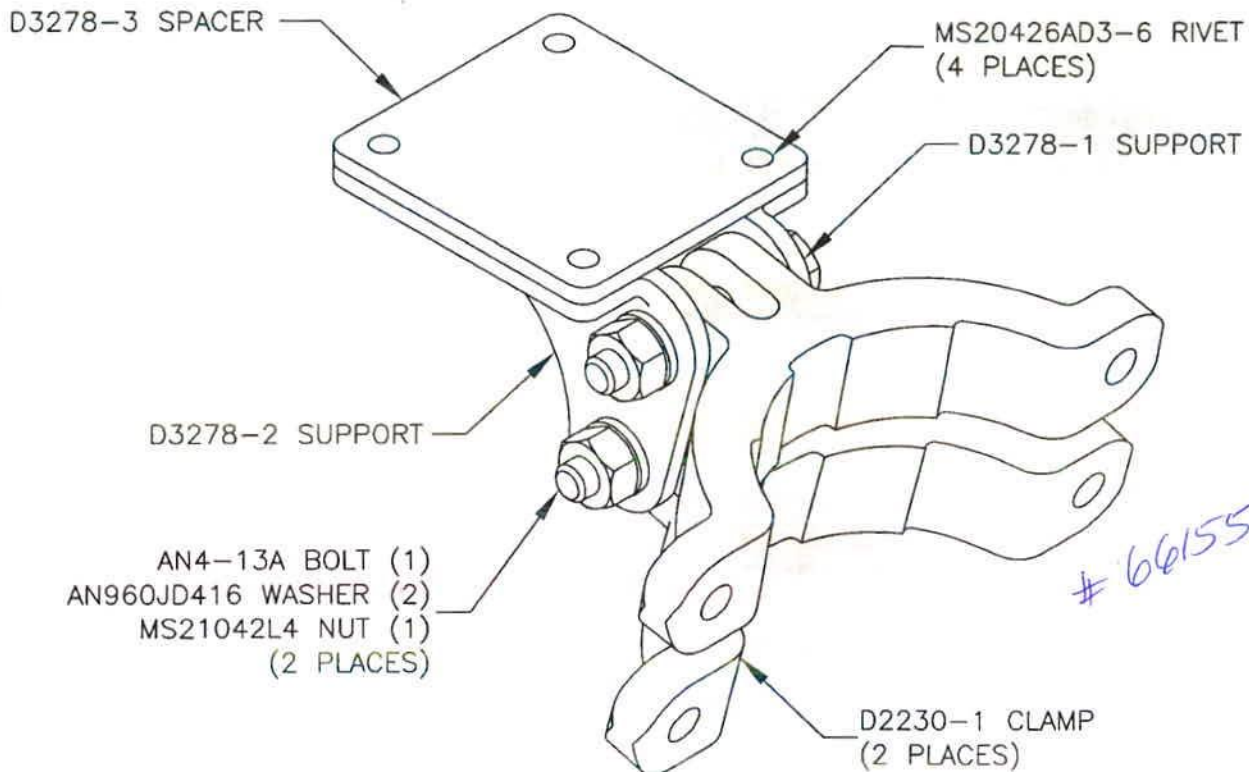
NOTE: Date & initial all entries

DART

DESIGN 97	DRAWN BY BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-06

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

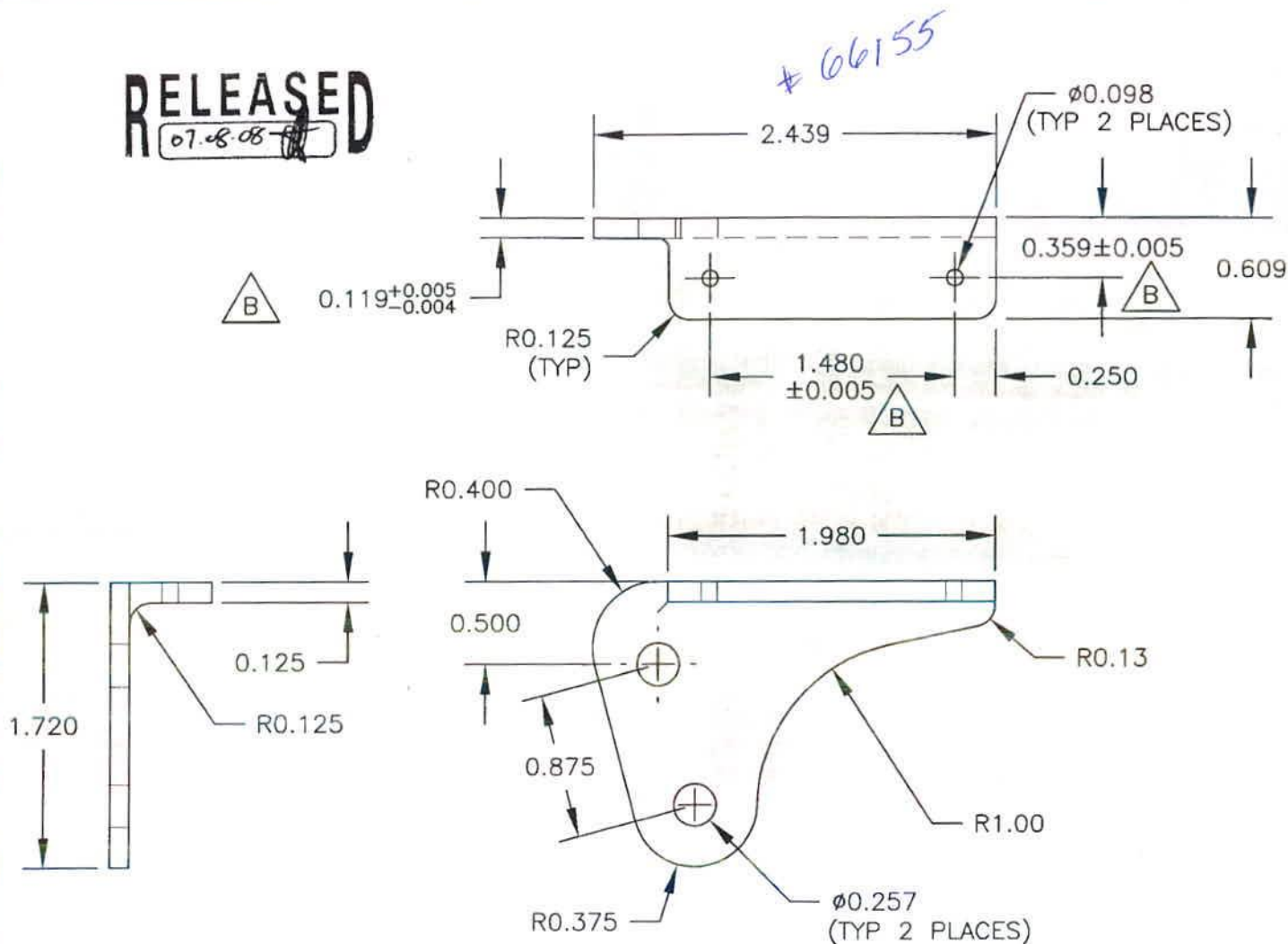
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DART

DESIGN <i>gp</i>	DRAWN BY <i>dc</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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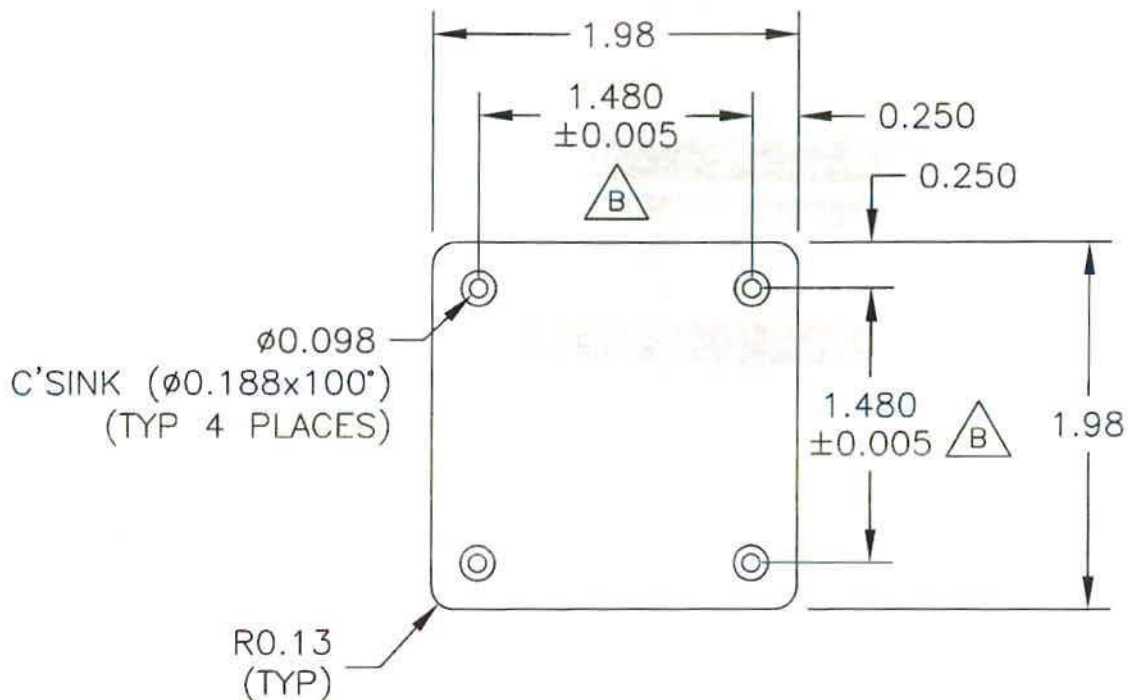
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DESIGN <i>GP</i>	DRAWN BY <i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08



D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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